

Ship Aug 7

Work Order ID 164554

Friday, July 21, 2017 8:50:17 AM

164554

Page 1

Item ID: D4979-1

Revision ID:

Item Name: Bracket

Start Date: 7/21/2017 Start Qty: 5.00 *5*

Required Date: 8/2/2017 Req'd Qty: 5.00 *5*

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4979

B

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.19

(62)

0217/07/31

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.05

(62)

0217/07/31

Work Order ID 164554

Friday, July 21, 2017 8:50:17 AM

164554

Page 2

Item ID: D4979-1

Revision ID:

Item Name: Bracket

Start Date: 7/21/2017 Start Qty: 5.00

Required Date: 8/2/2017 Req'd Qty: 5.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.10

Quality Control

DAS
38
9-89

JUL 31 2017

130

Bend as per dwg
NC BRAKE

0.19

130

Brake NC

Memo

0.37

Brake NC

DAS
30
9-89

JUL 31 2017

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.10

Quality Control

DAS
38
9-89

JUL 31 2017

Friday, July 21, 2017 8:50:17 AM

Page 3

Packaging

Work Order ID 164554

Friday, July 21, 2017 8:50:17 AM

164554

Page 4

Item ID: D4979-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 7/21/2017 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 8/2/2017 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.50

Quality Control

17/8/9
AUG 08 2017

Picklist Print

Friday, July 21, 2017 8:50:15 AM

Page 1

Work Order ID: 164554

164554

Parent Item: D4979-1

D4979-1

Parent Item Name: Bracket

Start Date: 7/21/2017

Required Date: 8/2/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.11.18 NEW ISSUE DD VERF:JLM
REV:B 14.06.16 AS PER DWG REV.B DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

13.2920

0.028

0.147368

M304S16GA

017/07/231

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT010

13.292

ml36896

0.3

ml37110

0.132

ml37175

1.1

ml37341

2.62

ml37400

3.9

ml37844

5.24

136327

.2

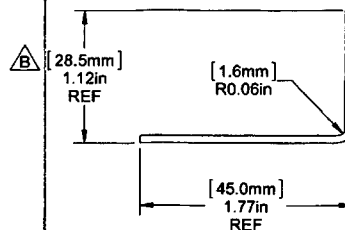
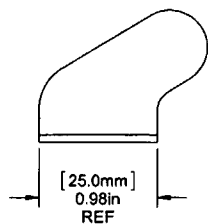
164554

FIRST ARTICLE INSPECTION CHECKLIST

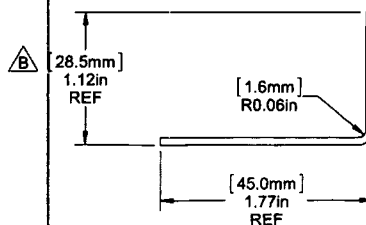
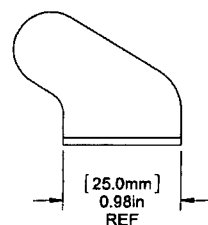
[illegible]

Measured by: <i>me</i>		Audited by: <i>me</i>		Preliminary Approval: <i>me</i>	
Date: <i>17/07/31</i>		Date: <i>17/07/2017</i>		Date: <i>17/07/2017</i>	

Rev	Date	Change	Revised by	Approved
A	14.09.25	New Issue	KJ	<i>[Signature]</i>



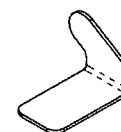
D4979-1 BRACKET



D4979-2 BRACKET



w/o 160554



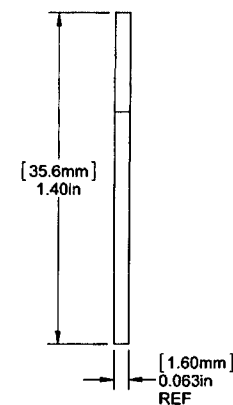
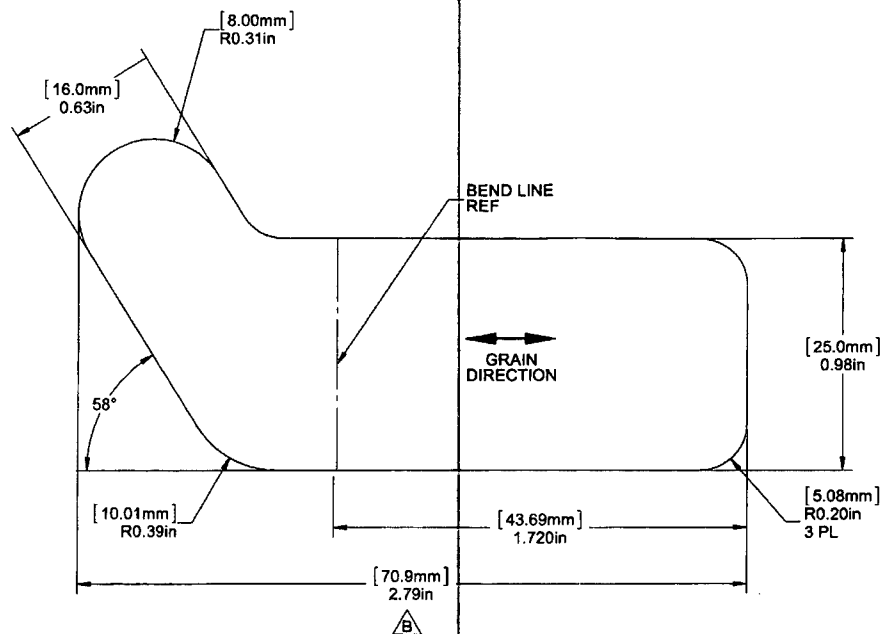
RELEASED
2014-06-11

NOTES:

- 1) MATERIAL: MAKE FROM D4979-1F
- 2) FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4979-1" OR "D4979-2" REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.05 lbs (0.02 kgs)

APPROVED

B	REVISED D4979 -1/-2 OVERALL HEIGHT (ZN BS-1, ZN DS-1, ZN BS-2)	AK	14.05.30
A	NEW ISSUE	DC	13.11.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4979	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.05.30	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4979-1F FLAT PATTERN BRACKET

RELEASED
2014-06-13
W

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs (0.02 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4979-1-b.IGES

APPROVED

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4979	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.05.30	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	